

Work Order ID 5565 PRELIMINARY DUE

January 27, 2010 9:23:39 AM



Page 1

Item ID: D4005-7

Revision ID:

Item Name: Angle

Start Date: 1/27/10 Start Qty: 2.00



Required Date: 2/02/10 Req'd Qty: 2.00



Reference:

Approvals:

Process Plan: *PL*

Date: *10-1-27*

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4005

A-PRELIM

New Rev A 10-1-27

0.00

Waterjet

Memo

0.00

B 10-1-27

FLOW CNC Waterjet

1-Cut as per Dwg
Dwg Rev: *PRE*
Prog Rev: *LM*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

JS 10/01/08

(4)

B 10-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55658

January 27, 2010 9:23:39 AM



Page 2

Item ID: D4005-7

Accept

Revision ID:

Item Name: Angle

Start Date: 1/27/10 Start Qty: 2.00



Required Date: 2/02/10 Req'd Qty: 2.00



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan

Code

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

→ S1010128

130



Brake NC

Brake NC

Bend as per dwg

0.00

Sj 1010101

(x4)

x

140



HandFinish

Hand Finishing

Memo

0.00

QCS insert to current step → S1010101

(x4)

f

150



HandFinish

Hand Finishing

Memo

0.00

BL 10-02-01

(x4)

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Gty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55658

January 27, 2010 9:23:39 AM



Page 3

Item ID: D4005-7

Accept

Revision ID:

Item Name: Angle

Start Date: 1/27/10 Start Qty: 2.00



Required Date: 2/02/10 Req'd Qty: 2.00



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Setup Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

160



QC

Quality Control

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

10/02/01

X 4 6

170



Packaging

Packaging

Identify as per dwg & Stock Location: 9117

0.00

0.00

10/02/01

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

POSITIVE RECALL

EFFECTIVE 10/01/27 AUTH U

RELEASED

DATE 10/06/28 Q44

10/06/28 HJ
R10-2-15
U
HJ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 27, 2010 9:23:43 AM

Page 1

Work Order ID: 55658



Parent Item: D4005-7



Parent Item Name: Angle

Comments: IPP rev A 10.01.21 new issue Prelim EC verified by:DD

Start Date: 1/27/10

Required Date: 2/02/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	509.7133	0.0592	.2		

2024-T3 .040 sheet



BS 10-1-27

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	509.7132789	
110305	184	
110337	6.4	
111786	32.0665789	
112291	49.4264	
112331	82.8641	
113162	154.9562	
113005		

(4)

113005

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	55658
Description: ANGLE	Part Number:	D4005-7
Inspection Dwg: D4005-7 Rev: DRF Lim		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

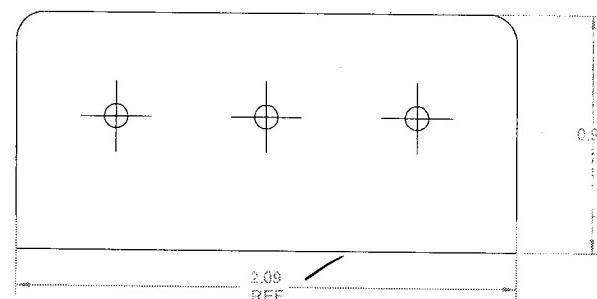
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Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-27	Date:	10/01/26	Date:	N/A

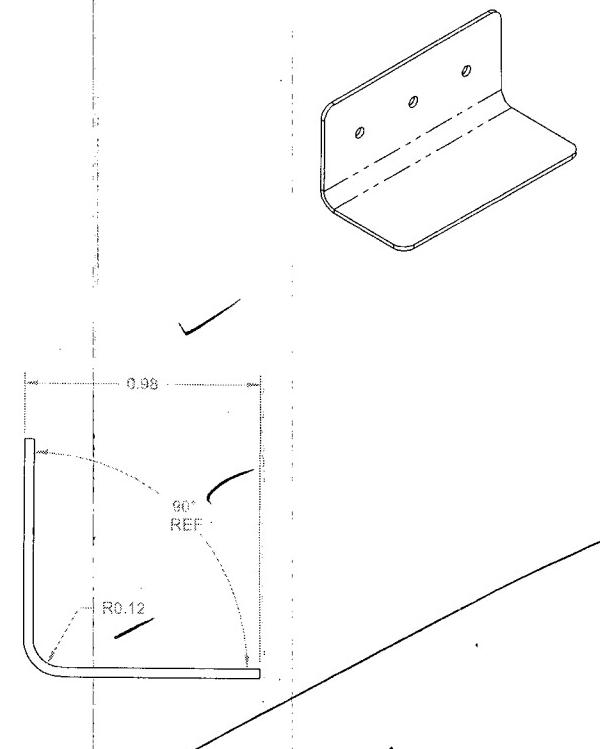
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

1/100628

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-7	JCA-M47-2-07



D4005-7 ANGLE
MADE FROM D4005-7F



See Rev A

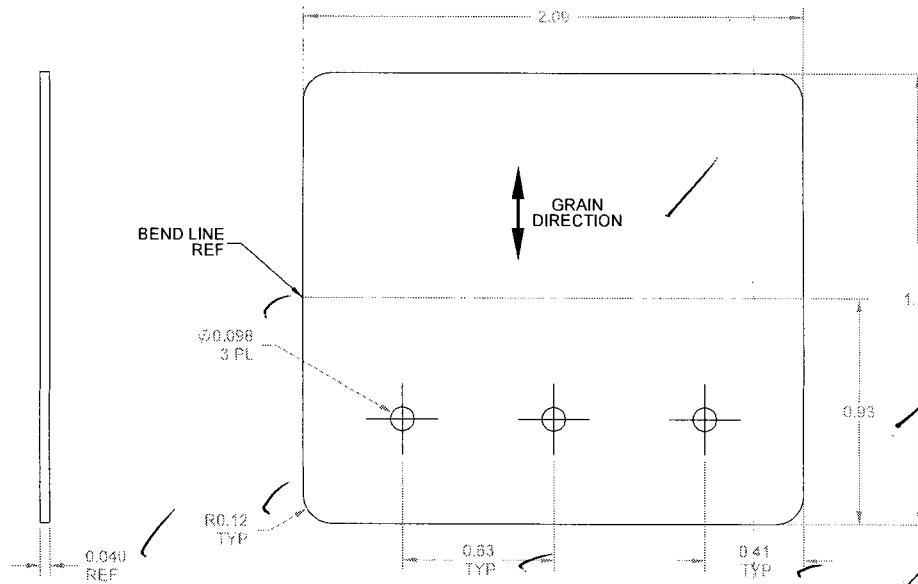
PRELIMINARY ISSUE

\$ 09.10.19

- NOTES:
- 1) MATERIAL: MADE FROM D4005-7F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-7" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. PA1
APPROVED		D4005
DE APPR.		SHEET 8 OF 15
DATE	09.10.19	TITLE
		FORWARD RESTRAINT
		NTS

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D4005-7F FLAT PATTERN

PRELIMINARY ISSUE

09.10.19

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	1	DRAWN	2	CHECKED	3	MFG. APPR.	4	APPROVED	5	DE APPR.	6
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA											
DRAWING NO. D4005 REV. PA1											
SHEET 9 OF 15 SCALE											
TITLE FORWARD RESTRAINT NTS											
DATE 09.10.19											

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8

7

6

5

4

3

2

1

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-7	JCA-M47-2-07

D

D

C

C

B

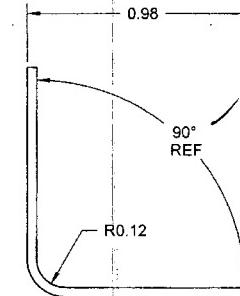
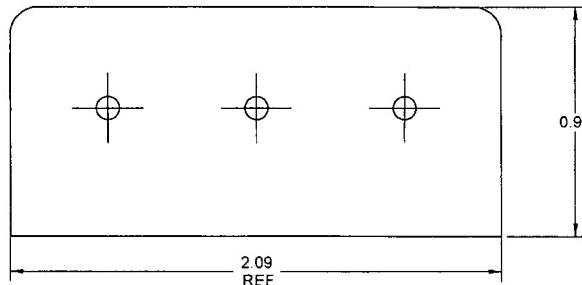
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A

A

NOTES:

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-7" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs



RELEASED
2010-05-05
WFO 55658

DESIGN	<input checked="" type="checkbox"/>	DART AEROSPACE LTD
DRAWN	<input checked="" type="checkbox"/>	HAWKSLEY, ONTARIO, CANADA
CHECKED	<input checked="" type="checkbox"/>	REV. A
MFG. APPR.	<input checked="" type="checkbox"/>	D4005 SHEET 8 OF 15
APPROVED	<input checked="" type="checkbox"/>	TITLE SCALE
DE APPR.	<input checked="" type="checkbox"/>	RESTRAINT NTS
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8

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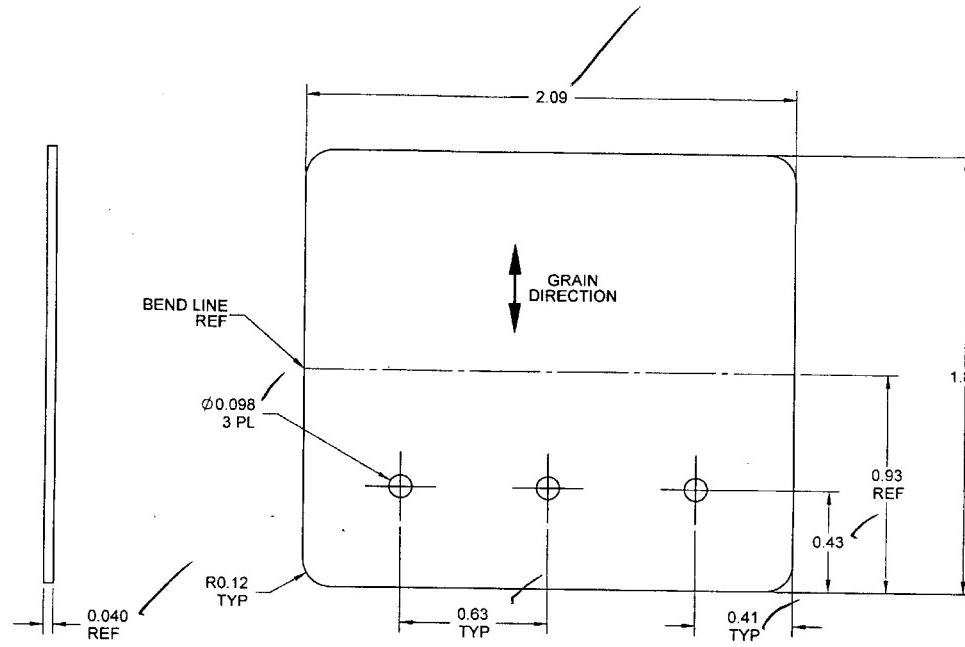
5

4

3

2

1



D4005-7F FLAT PATTERN

W05565⁸

RELEASED
R 2010-05-05
NP

NOTES:

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DESIGN	<i>EE</i>	DART AEROSPACE LTD
DRAWN	<i>EE</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>EE</i>	REV. A
MFG. APPR.	<i>EE</i>	DRAWING NO.
APPROVED	<i>EE</i>	SHEET 9 OF 15
DE APPR.	<i>EE</i>	TITLE
DATE	10.02.05	SCALE
		NTS

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